# Work Order ID 71579

*Wednesday, July 06, 2011 1:21:32 PM*



**Item ID:** D3536-23 **Accept** **Setup Start** **Stop**

**Revision ID:**

**Item Name:** Gasket

**Start Date:** 7/6/2011 **Start Qty:** 12.00 **Cust Item ID:**

**Required Date:** 7/20/2011 **Req'd Qty:** 12.00 **Customer:**

**Reference:**

**Approvals:** **Process Plan:** CL **Date:** 11/07/06 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| **Draw Nbr** | **Revision Nbr** | | | | | | | | |
| D3536 | Rev A | | | | | | | | |
| 100 | FLOW WATER JET | 0.00 | | | | | | | |
| Waterjet | **Memo** | 0.00 | | | | 11-7-12 | | | |
| FLOW CNC Waterjet | 1-Cut as per Dwg D3536 ☐Dwg Rev: A ☐Prog Rev: A ☐2-Deburr if necessary | | | | | | | | |
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| QC | **Memo** | 0.00 | | | | 11-7-12 | | | |
| Quality Control | | | | | | | | | |
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| QC | **Memo** | 0.00 11/07/12 | | | | XL2 | | | |
| Quality Control | | | | | | | | | |

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

# Work Order ID 71579

*Wednesday, July 06, 2011 1:21:32 PM*



**Item ID:** D3536-23 **Accept** **Setup Start**

**Revision ID:** **Stop**

**Item Name:** Gasket

**Start Date:** 7/6/2011 **Start Qty:** 12.00 **Cust Item ID:**

**Required Date:** 7/20/2011 **Req'd Qty:** 12.00 **Customer:**

**Reference:**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 130 | Identify as per dwg & Stock Location: FP | 0.00 | | | | | | | |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | | | | | | | 11/7/12 | 12 | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | 11/7/13 | | |

MF 11-07-12

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
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| | | | | | | | | |

**NOTE:** Date & initial all entries

# Picklist Print

*Wednesday, July 06, 2011 1:21:29 PM*



**Work Order ID:** 71579

**Parent Item:** D3536-23

**Parent Item Name:** Gasket

**Start Date:** 7/6/2011 **Required Date:** 7/20/2011

**Start Qty:** 12.00 **Required Qty:** 12.00

**Comments:** IPP Rev:A New Issue 07-02-14 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| MNEO60S.063 | | Purchased | No | | | 100 | sf | 369.1800 | 1.3365 | 17.82 | | | |
| NEOPRENE SHEET 0.063 | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|---|---|---|
| MAT052 | 369.18 | |
| 117295 | 55.68 | |
| 118026 | 313.5 | |

11-7-12

12

118026

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
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| | | | | | | | | |

**NOTE:** Date & initial all entries

| DART AEROSPACE LTD | Work Order: | 71579 |
|---|---|---|
| | | |
| **Description:** Gasket | Part Number: | D3536-23 |
| | | |
| **Inspection Dwg:** D3536 **Rev:** A | | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| 52.85 | +/-0.030 | 52.88 | ✓ | | T B01 | |
| 48.20 | +/-0.030 | 48.20 | ✓ | | T | |
| 44.70 | +/-0.030 | 44.70 | ✓ | | T | |
| 39.31 | +/-0.030 | 34.31 | ✓ | | T | |
| 33.92 | +/-0.030 | 33.92 | ✓ | | T | |
| 28.53 | +/-0.030 | 28.53 | ✓ | | T | |
| 23.14 | +/-0.030 | 23.14 | ✓ | | T | |
| 17.75 | +/-0.030 | 17.75 | ✓ | | T | |
| 14.25 | +/-0.030 | 14.25 | ✓ | | T | |
| 9.50 | +/-0.030 | 9.50 | ✓ | | T | |
| 4.75 | +/-0.030 | 4.75 | ✓ | | T | |
| 8.00 | +/-0.030 | 8.00 | ✓ | | T | |
| 16.00 | +/-0.030 | 16.00 | ✓ | | T | |
| 24.00 | +/-0.030 | 24.00 | ✓ | | T | |
| 32.00 | +/-0.030 | 32.00 | ✓ | | T | |
| 39.00 | +/-0.030 | 39.00 | ✓ | | T | |
| 48.00 | +/-0.030 | 48.00 | ✓ | | T | |
| 0.30 | +/-0.030 | .304 | ✓ | | V B07 | |
| 0.30 | +/-0.030 | .307 | ✓ | | V | |
| 1.89 | +/-0.030 | 1.888 | ✓ | | V | |
| Ø0.19 | +0.005/-0.001 | .190 | ✓ | | V | |
| | | | | | | |

| Measured by: | B |
|---|---|
| Date: | 11-7-12 |

| Audited by: | B |
|---|---|
| Date: | 11/07/12 |

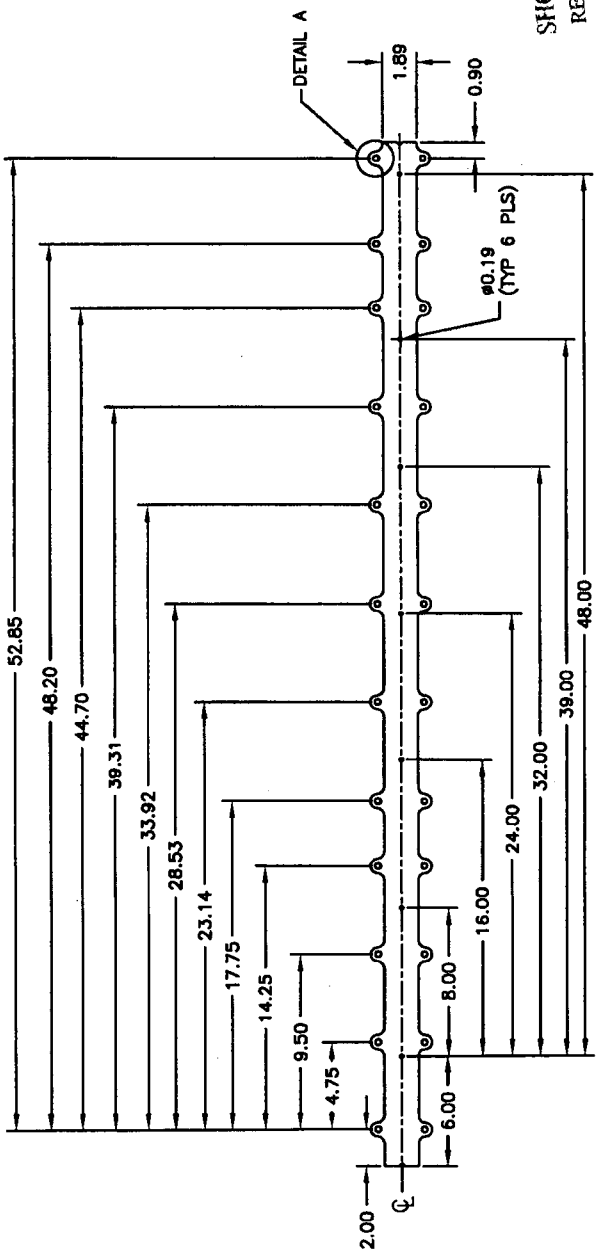
| Prototype Approval: | N/A |
|---|---|
| Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|---|---|---|---|---|
| A | 07.03.14 | New Issue | KJ/JLM | |

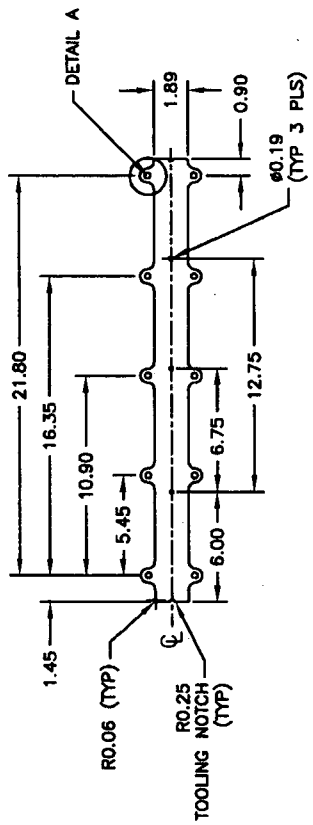
| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
|---|---|---|---|
| CB | CB | | |
| CHECKED | APPROVED | DRAWING NO. | REV. A |
| PH | | D3536 | SHEET 3 OF 6 |
| DATE | | TITLE | SCALE |
| 06.10.25 | | GASKET | 1:10 |

RELEASED
07.02.12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71579




D3536-23 GASKET




D3536-25 GASKET

NOTES
1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT ℄
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
7) SEE PAGE 6 FOR DETAILS AND SECTION